

Work Order ID 132306

Wednesday, May 06, 2015 1:23:14 PM

132306

JUNE 6 2015
U/R
Page 1
K/S/M

Item ID: D169-841-013

Accept

N900040100

Setup Start

NS1

Revision ID: U/R

AGUSTA # 6FAS40V0013

Item Name: AW169 Upper Cutter Deflector

Stop

NS2

Start Date: 5/06/15

Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/03/15

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

15-5-6

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DAS
12
9-89

IIN-D169-841

Rev. C 15/6/15

0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D169-841-013 CHG001

DAS
12
9-89

CHG002
15/6/15

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

5/15/6668

(x2)

2 15/6/15

JUN 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Wednesday, May 06, 2015 1:23:14 PM

132306

Page 2

Accept

N900040100

Setup Start *NS1*

Item Name: AW169 Upper Cutter Deflector

Stop *NS2*

Start Date: 5/06/15 **Start Qty:** 2.00

~

Cust Item ID:

Required Date: 6/03/15 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

130

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D169-841-013

0.00

140

140

QC21- Final Inspection - Work Order Release

0.00

OC

Memo

Quality Control

MS-6-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Wednesday, May 06, 2015 1:23:31 PM

Page 1

Work Order ID: 132306

132306

Parent Item: D169-841-013

D169-841-013

Parent Item Name: AW169 Upper Cutter Deflector

Start Date: 5/06/15

Required Date: 6/03/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-07-17 JLM VERIFIED BY:DD IPP
REV:B 13.10.18 IIN REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4821-1 S 72 *D4821-1* Windshield Deflector	DAS 6 9-89	Manufactured	No				Each	0.0000		2			
		Pair Attached							**	131309 x 2			Mo
D4822-1 S 72 *D4822-1* Upper Deflector, LH	DAS 6 9-89	Manufactured	No				Each	0.0000		2		JUN 05 2015	
		Pair Attached							**	132310 x 2			Mo
D4822-2 S 72 *D4822-2* Upper Right Deflector	DAS 6 9-89	Manufactured	No				Each	0.0000		2		JUN 05 2015	
		Pair Attached							**	114009 x 2			Mo
D4840-041 S 72 *D4840-041* Upper Cutter Assembly	DAS 6 9-89	Manufactured	No				Each	0.0000		2		JUN 05 2015	
		Pair Attached							**	B132312 x 2			Mo
D4857-1 X *D4857-1* Wiper Deflector		Manufactured	No				Each	0.0000		4		JUN 05 2015	
		N/A							**				
D4944-1 X *D4944-1* Gasket		Manufactured	No				Each	44.0000		4			
									**				

Location

Loc Qty

Loc Code

GA

44

109043

44

D4857-041 DAS 6 9-89 X4

Pair attached

B133350 x 4

JUN 05 2015

~~D4842-041 x 2~~

JUN 05 2015

JUN 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause	FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐		

Picklist Print

Page 2

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Work Order ID: 132306

132306

Parent Item: D169-841-013

D169-841-013

Parent Item Name: AW169 Upper Cutter Deflector

Start Date: 5/06/15

Required Date: 6/03/15

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-12

Purchased

No

Each

138.0000

20

**

MS27039-1-12

Screw

DAS
6
9-89

Location

Loc Qty

Loc Code

ST285

138

m125654

12

m128799

26

m131317

100

20
12
8

JUN 05 2015

DQA: _____ Date: _____

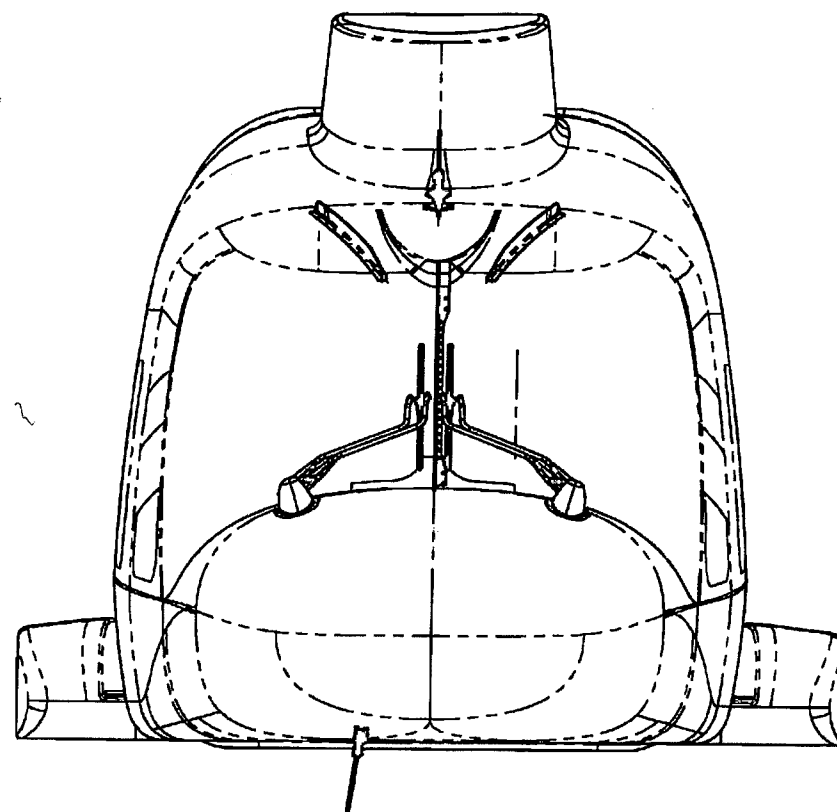


WORK ORDER NON-CONFORMANCE / UPDATE

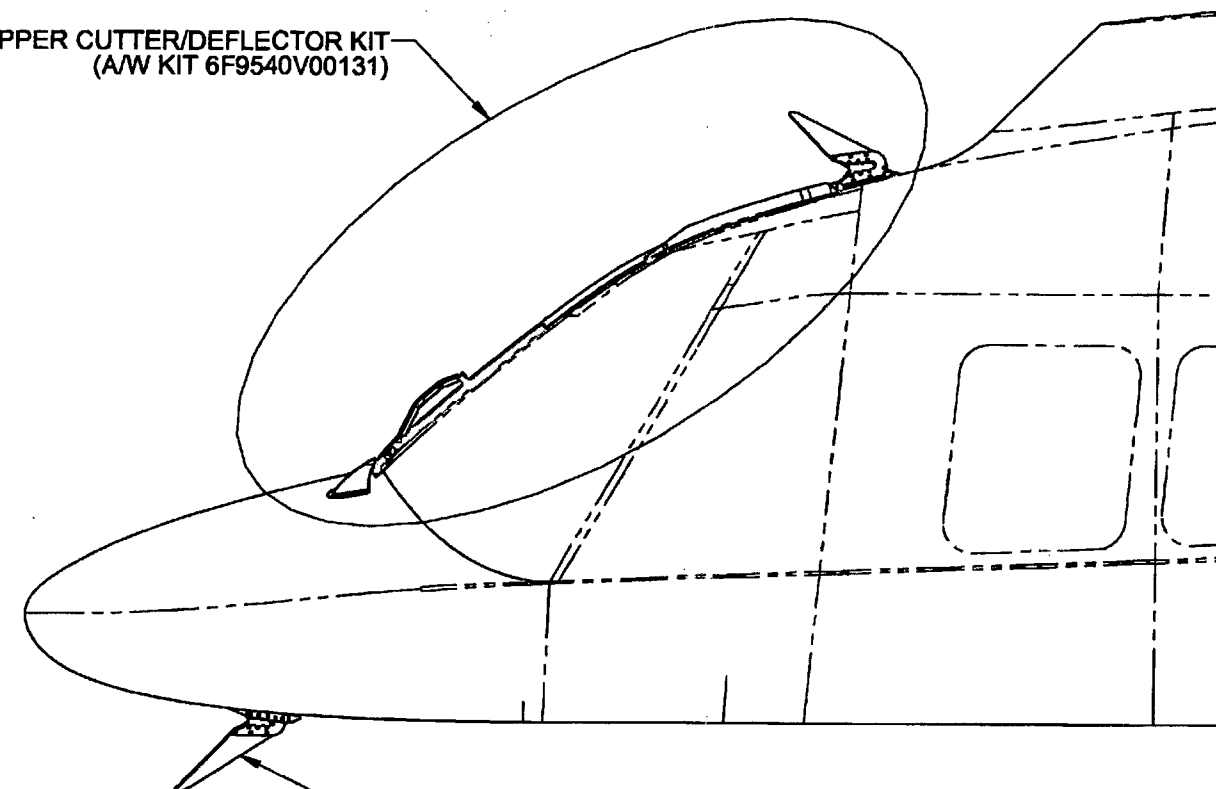
QA Closed: _____ Date: _____

Work Order update only ☐

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D169-841-011 AW169 CABLE CUTTER SYSTEM



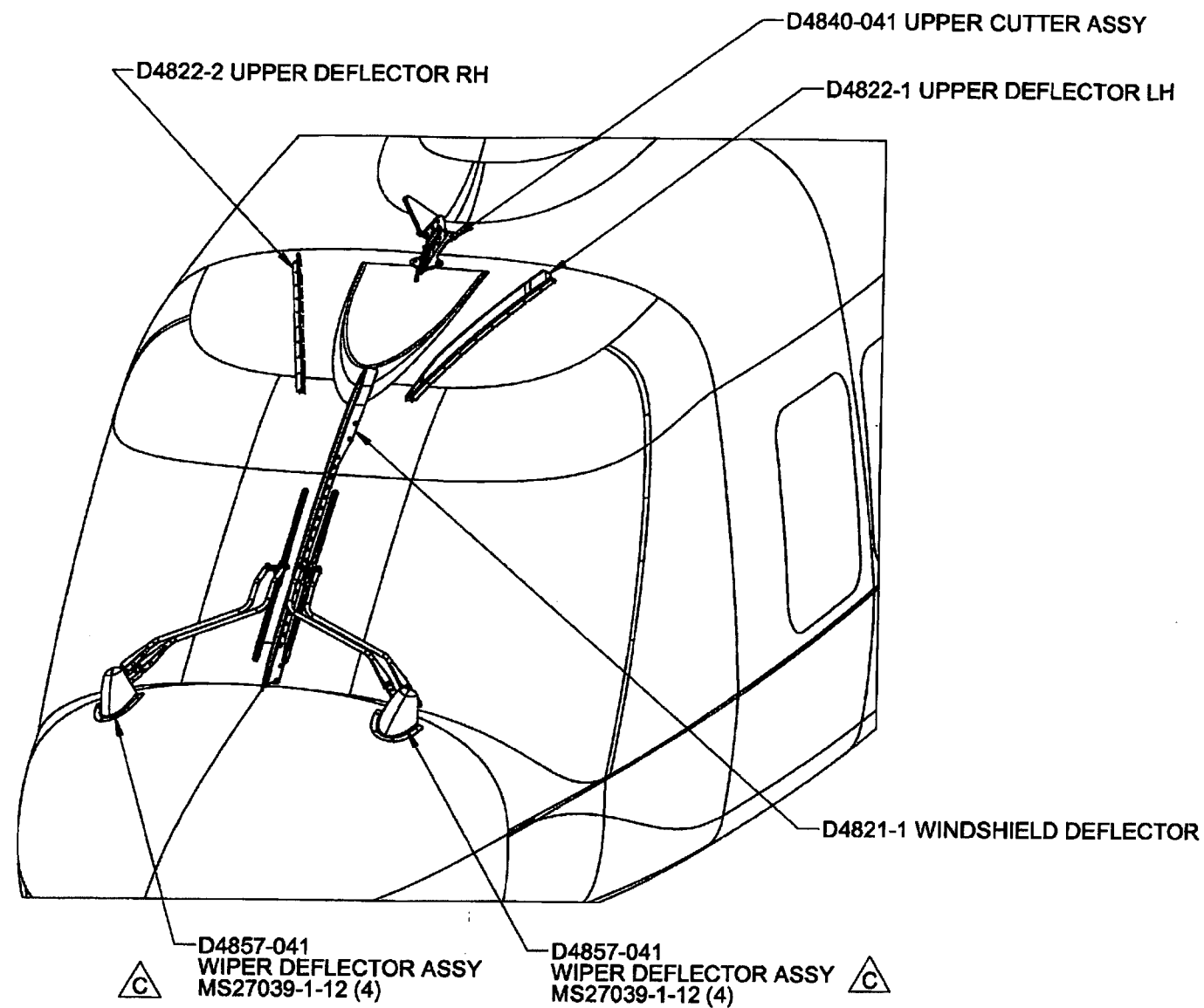
D169-841-013 UPPER CUTTER/DEFLECTOR KIT
(A/W KIT 6F9540V00131)

D169-841-015 LOWER CUTTER KIT
(A/W KIT 6F9540V00231)

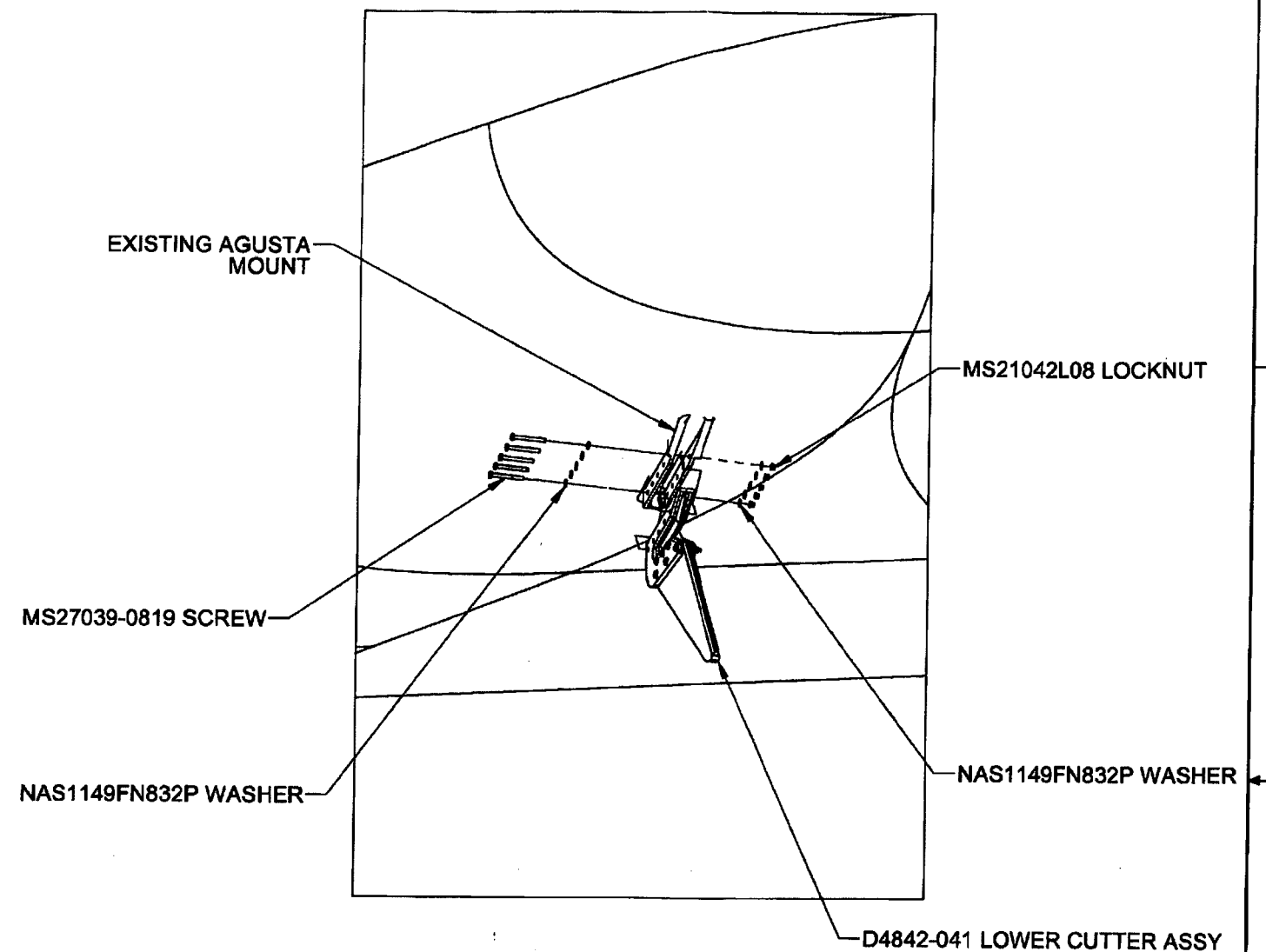
-011	-013	-015	DART P/N	AGUSTA WESTLAND P/N
X			D169-841-011 CABLE CUTTER SYSTEM	TBD
1	X		D169-841-013 UPPER CUTTER/DEFLECTOR KIT	6F9540V00131
1		X	D169-841-015 LOWER CUTTER KIT	6F9540V00231
	1		D4821-1 WINDSHIELD DEFLECTOR	TBD
	1		D4822-1 UPPER DEFLECTOR LH	TBD
	1		D4822-2 UPPER DEFLECTOR RH	TBD
	1		D4840-041 UPPER CUTTER ASSY	TBD
	2		D4857-041 WIPER DEFLECTOR ASSY	TBD
	8		MS27039-1-12 SCREW	N/A
	TBD		TBD-FASTENERS	N/A
		1	D4842-041 LOWER CUTTER ASSY	TBD
		5	MS21042L08 LOCKNUT	N/A
		5	MS27039-0819 SCREW	N/A
		10	NAS1149FN832P WASHER	N/A



C	D4857-041 WAS D4857-1 (D4944-1 GASKETS NOW IN D4857 DRAWING). PARTS LIST: MS27039-1-12 QTY WAS 10	AJS	15.05.20
B	ADD D4944-1 GASKET (ZN A8-1) (ZN B6-2, B8-2) ADD MS27039-1-12 SCREW, D4857-1 WAS D4857-041-042	DW	13.09.23
A	NEW RELEASE	DB	13.07.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		IIN-D169-841	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		AW169 CABLE CUTTER SYSTEM	NTS
DATE	15.05.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D169-841-013 UPPER CUTTER/DEFLECTOR KIT



D169-841-015 LOWER CUTTER KIT

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JLM	IIN-D169-841	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	AW169 CABLE CUTTER SYSTEM	NTS
DATE	15.05.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	